

**Work Order ID 45188**

Wednesday, September 02, 2009 10:13:29 A

Page 1

Item ID: D350-602-013

Accept

Revision ID: F3/A/H

Item Name: Heli-Utility-Pod, LH

Start Date: 7/15/2009 Start Qty: 1.00

Required Date: 8/3/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile &amp; type labels per PPP D350-602-013

CHG001

S 8/10/02

HJ for JLD 09/03/16

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 2131 Description: ☐ D2202-1 Lid ☐ D2202-5  
Base ☐ Supplier: Delastek ☐ Conformity Certificate and Process sheet required  
☐  
Ship Parts From Step 2 & 3

CZ 09/02/04 (1)

120

0.00



Receive &amp; Inspect for Damage &amp; Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

CZ 9/3/03 (1)

**Work Order ID 45188**

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Page 2

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

Visual inspection. Check for void spot and pins.

140

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D2694□2-Install label D2258-160 on Pod Assembly as per Dwg D2694 at location of max pod load label on Purchasing2 of dwg □3-Modify as per DEO 9217

150

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

ⓧ

/

IT 09.09.23

P10

1

09.09.29

W/O: 45188

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05-10-01	140	Add label D3605-1 per DS19388 to install atassy. See NC below.  perm change		05/10/05		DS142	05-10-01

Part No: D350-602-013 PAR #: 09-034 Fault Category: Eng - Drawing NCR: Yes ☒ No ☐ DQA: 7 Date: 05/10/05  
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 45188

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-09-29	140	AD64 ABS Qty 2 rivets were too short to install in the bottom radius of the clevis. Thicker in the radius area. RC process.	DS142	Pick + install Qty 2 AD66 ABS rivets. M 45188 See PAR 09-034	ET 09-09-29	05-09-29	DS142	05-09-29
07-09-29	140	install D3605-1 <del>B52506</del> as per DS2 9388	DS142	pick + install Qty 1 D3605-1 Decal B52506 See PAR 09-034.	ET 09-09-29	05-10-01	DS142	05-10-01

NOTE: Date &amp; initial all entries

**Work Order ID 45188**

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Item ID: D350-602-013

Accept

Revision ID: F3/A/H

Item Name: Heli-Utility-Pod, LH

Start Date: 7/15/2009 Start Qty: 1.00

Required Date: 8/3/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

8/7/16 @ SP

170



QC

Quality Control

QC3- Inspect Part Finish

QC4  
S

Memo

0.00

0.00

⇒ 8/21/06

Ⓟ Ⓟ

180



Packaging

Packaging

Packaging

Memo

0.00

0.00

Identify and pack for shipping as per PPP D350-602-013  
□ Location: \_\_\_\_\_ □ PPP Rev: 1

1/29/10/02 ①

**Work Order ID 45188**

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Item ID: D350-602-013  
Revision ID: F3/A/H  
Item Name: Heli-Utility-Pod, LH

Accept



Setup Start



Stop



Start Date: 7/15/2009 Start Qty: 1.00  
Required Date: 8/3/2009 Req'd Qty: 1.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/10/05  
R 09-10-2

# Picklist Print

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Page 1

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Work Order ID: 45188



Parent Item: D350-602-013RevF3/A/H



Parent Item Name: Heli-Utility-Pod, LH

Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AD62ABS  rivet		Purchased	No				Each	185.0000	38.0000			

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

185

109582

1

110804

184

Each

145.0000

19.0000

110804 54

✓ AN4-5A



Bolt

Purchased

No

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

145

100089

6

106605

6

108672

1

109061

9

110844

100

111650

23

111650 9/9/9 54 (1X)

# Picklist Print

Wednesday, September 02, 2009 10:13:55 AM

Work Order ID: 45188

Parent Item: D350-602-013RevF3/A/H

Parent Item Name: Heli-Utility-Pod, LH


Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN4-6A  Bolt		Purchased	No				Each	846.0000	1.0000			

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	846	
102602	3	
105810	15	
107534	1	
109545	2	
110399	27	
111279	498	
112314	300	

111279 54

✓ AN526C632R7



Screw

Purchased

No

Each

307.0000 2.0000

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	307	
107715	7	
112385	300	

112385 9/2/16 54

# Picklist Print

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Work Order ID: 45188

Parent Item: D350-602-013RevF3/A/H

Parent Item Name: Heli-Utility-Pod, LH


Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN960JD416  Washer		Purchased	No				Each	9,139.000	21.0000			


Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	9139
102929	2
105906	4
107321	23
107939	114
108161	553
108827	31
109249	69
110523	340
111279	101
111916	3015
112314	4887
16941	0

11/9/16 34

✓ AN960JD6  Washer		Purchased	No				Each	1,501.000	2.0000			
--	--	-----------	----	--	--	--	------	-----------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1501
104537	1114
6085	387

6085 9/9/16 Q29



# Picklist Print

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Work Order ID: 45188

Parent Item: D350-602-013RevF3/A/H

Parent Item Name: Heli-Utility-Pod, LH


Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D2204-9RevB  Latch, Rubber		Manufactured	No				Each	52.0000	5.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	52	
39689	52	

39689 SP

✓ D2258-160RevC  Placard		Manufactured	No				Each	10.0000	1.0000			
--	--	--------------	----	--	--	--	------	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	10	
32986	10	

32986 SP

✓ D2429-041RevC1  Spring Clip Assembly		Manufactured	No				Each	19.0000	1.0000			
--	--	--------------	----	--	--	--	------	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	19	
36272	19	

36272 9/2/10 @ SP

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Shop Packet Print

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# Picklist Print

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Wednesday, September 02, 2009 10:13:55 AM

Work Order ID: 45188

Parent Item: D350-602-013RevF3/A/H

Parent Item Name: Heli-Utility-Pod, LH




Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D2462RevA1  Seal		Manufactured	No				f	791.0004	14.1660			
				<u>Warehouse</u>	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse								
				ST404				791.0004				
				48530				791.0004				
✓ D2528-1RevC1  Backer Plate		Manufactured	No				Each	18.0000	5.0000			
				<u>Warehouse</u>	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse								
				ST				18				
				43744				3				
				47602				15				
✓ D2528-3RevC1  Backer Plate		Manufactured	No				Each	8.0000	4.0000			
				<u>Warehouse</u>	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse								
				ST				8				
				45242				8				

48530 SF

43744 SO  
47602

45242 9/9/16 @ SO

# Picklist Print

Wednesday, September 02, 2009 10:13:55 AM

Work Order ID: 45188

Parent Item: D350-602-013RevF3/A/H

Parent Item Name: Heli-Utility-Pod, LH




Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D2569RevB  Hinge		Manufactured	No				Each	11.9200	1.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>26909</div> <div>46839</div> <div>Loc Qty</div> <div>11.92</div> <div>5.92</div> <div>6</div> <div>Loc Code</div> <div>26909 SP</div>												
✓ D3001-1RevB  Doubler		Manufactured	No				Each	7.0000	3.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>36277</div> <div>Loc Qty</div> <div>7</div> <div>7</div> <div>Loc Code</div> <div>36277 SP</div> <div>put back in stock</div> <div>Already installed by Delastek</div>												
✓ D3007-041RevA1  Strut		Manufactured	No				Each	1.0000	1.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>36300</div> <div>Loc Qty</div> <div>1</div> <div>1</div> <div>Loc Code</div> <div>36300 9/2/09 @ SP</div>												

# Picklist Print

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Work Order ID: 45188

Parent Item: D350-602-013RevF3/A/H

Parent Item Name: Heli-Utility-Pod, LH

Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

✓ D3048-1RevA2

Manufactured

No

Each

1.0000

1.0000



Doubler

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

45491

1

Each

7.0000

1.0000

✓ D3495-1RevA

Manufactured

No



Placard

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

43778

7

Each

3.0000

1.0000

✓ K10002RevA

Manufactured

No



Pod Kit, 350

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

3

43865

1

47539

2

@ ch7002

put back  
in stock  
ST 09-09-23  
Already installed  
by Delasalle

45491 SP

43778 SP

43865

9/9/16 RSG

Wednesday, September 02, 2009 10:13:55 AM

Shop Packet Print

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# Picklist Print

Wednesday, September 02, 2009 10:13:55 AM

Work Order ID: 45188

Parent Item: D350-602-013RevF3/A/H

Parent Item Name: Heli-Utility-Pod, LH


Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ MS21042L06  Nut		Purchased	No				Each	449.0000	2.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

449

110123

11

110731

14

111548

1

112243 ✓

123

112243

SL

112369

100

112433

100

112465

100

✓ MS21042L4



Nut

Purchased

No

Each

8,459.000 20.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8459

107499

5

110507

417

111827

5996

112314

2000

15924

0

8182

41

9629

9629

9/9/16 (1) SL

### Material Requisitions

Part Number: AD66 ABS

Batch Number: 112787

R/S#: \_\_\_\_\_

Quantity: 42

Required by: RT Date: 09-09-28

#### **Used for**

Part Number: 0350-602-013

Batch Number: 45188

Approved by Purchaser: \_\_\_\_\_

Date: \_\_\_\_\_

Comments:

\_\_\_\_\_

\_\_\_\_\_

T:\TRANS\QAIMATERIAL REQ-A.DOC

### Material Requisitions

Part Number: D3605-1

Batch Number: B52508

R/S#: \_\_\_\_\_

Quantity: x1

Required by: RT Date: 09-09-30

#### **Used for**

Part Number: 350-602-013

Batch Number: 45188

Approved by Purchaser: \_\_\_\_\_

Date: \_\_\_\_\_

Comments:

\_\_\_\_\_

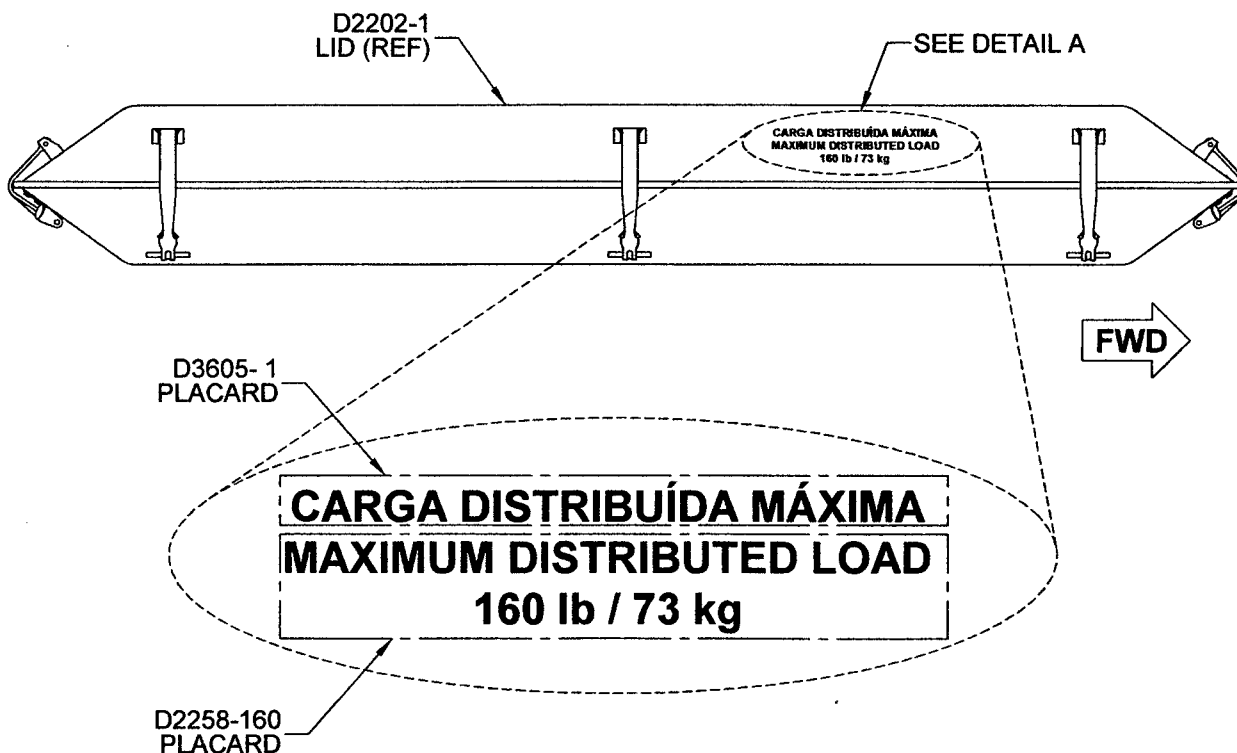
\_\_\_\_\_

T:\TRANS\QAIMATERIAL REQ-A.DOC

# DART SERVICE INSTRUCTION

When the D350-602-XXX Heli-Utility Pods are installed on a Brazilian registered aircraft, install the D3605-1 Placard above the D2258-160 Placard located on the D2202-1 Lid of the Heli-Utility Pod as follows:

1. Saturate a clean cotton cloth with 4105S Wash 'n' Wipe Degreaser or MEK (or equivalent) and wipe the surface to clean the entire area.
2. If necessary, touch up finish in accordance with ICA-D350-602.
3. Install D3605-1 Placard per Figure 1 using a 3M PA-1 Plastic Applicator (or equivalent) to blend out blisters as required.



## DETAIL A: INSTALLATION OF D3605-1 PLACARD

**FIGURE 1: D350-602-XXX HELI-UTILITY POD**  
(RH SHOWN, LH SIMILAR)

45188

A	NEW ISSUE	MB	07.09.04
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9388	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		PLACARD ADDITION	NTS
DATE	07.09.04	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Date: Tuesday, 03/02/2009 3:16:37 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HELI UTILITY POD
<b>Job Number</b> : 45188	
<b>Estimate Number</b> : 12400	
<b>P.O. Number</b> :	<b>Part Number</b> : D350602013
<b>This Issue</b> : 03/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2202,DEO9217,D2694
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : E/F3/A/H
<b>Previous Run</b> : 45188	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 28/02/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.02.03</u>	
<b>Comment</b> : Est Rev:A New Issue 06-05-01 JLM	
Est Rev:B Added D3495-1 06-05-17 JLM	
Est Rev:C 09-02-03 update dwg rev's DD verified by:EC	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

✓ DC

DOCUMENT CONTROL



**Comment:** Photocopy bluefile & type labels per PPP D350-602-013 CHG001

2.0

✓ D30011

Doubler



**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Doubler

Batch: B36277

Ship to Delastek

\* 3 e209/02/04 ①

3.0

✓ D30481

Doubler



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch: B45491

Ship to Delastek

C209/02/13 ①

4.0

✓ PG

PURCHASING



**Comment:** PURCHASING

Issue P/O: 8131

Description:

D2202-1 Lid

D2202-5 Base

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship Parts From Step 2 &amp; 3

C209/02/04 ①



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 03/02/2009 3:16:37 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY POD

Job Number: 45188

Part Number: D350602013

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 ✓ PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

6.0 ✓ QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2202 and DSI 9217. Visual inspection. Check for void spot and pins.

7.0 ✓ D22049 Latch, Rubber



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Rubber Latches

Batch: \_\_\_\_\_

8.0 ✓ D2429041 Spring Clip Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spring Clip Ass'y

Batch: \_\_\_\_\_

9.0 ✓ D2462 Seal



Comment: Qty.: 14.1660 f(s)/Unit Total : 14.1660 f(s)

Neoprene Seal 170.0" long

Batch: \_\_\_\_\_

10.0 ✓ D25281 Backer Plate



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Backer Plate

Batch: \_\_\_\_\_

11.0 ✓ D25283 Backer Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backer Plate

Batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 03/02/2009 3:16:37 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY POD

Job Number: 45188

Part Number: D350602013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0



D2569

Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge

Batch: \_\_\_\_\_

13.0



D3007041

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: \_\_\_\_\_

14.0



AD62ABS

rivet



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pop Rivets

Batch: \_\_\_\_\_

15.0



AN45A

Bolt



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Bolt

Batch: \_\_\_\_\_

16.0



AN46A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: \_\_\_\_\_

17.0



AN526C632R7

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch: \_\_\_\_\_

18.0



AN960JD6

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 03/02/2009 3:16:37 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY POD

Job Number: 45188

Part Number: D350602013

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

✓ AN960JD416

Washer



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

Batch: \_\_\_\_\_

20.0

✓ MS21042L4

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Batch: \_\_\_\_\_

21.0

✓ MS21042L06

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: \_\_\_\_\_

22.0

✓ D2258160

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: \_\_\_\_\_

23.0

✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2694

2-Install label D2258-160 on Pod Assembly as per Dwg D2694 at location of max pod load label on pg2 of dwg

3-Modify as per DEO 9217

24.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 03/02/2009 3:16:37 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY POD

Job Number: 45188

Part Number: D350602013

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0



K10002

Pod Kit, 350



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

350 Pod Kit

Batch: \_\_\_\_\_

27.0



D34951

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PLACARD

BATCH: \_\_\_\_\_

28.0



QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION KIT

29.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-602-013

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

30.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DESIGN A	DRAWN BY A	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED S	APPROVED S	DRAWING NO. DEO 9217	REV. A SHEET 1 OF 1
DATE 01.09.26		TITLE MOsaic POD MODIFICATION	SCALE NTS
A	01.09.26	NEW ISSUE	

# DART ENGINEERING ORDER

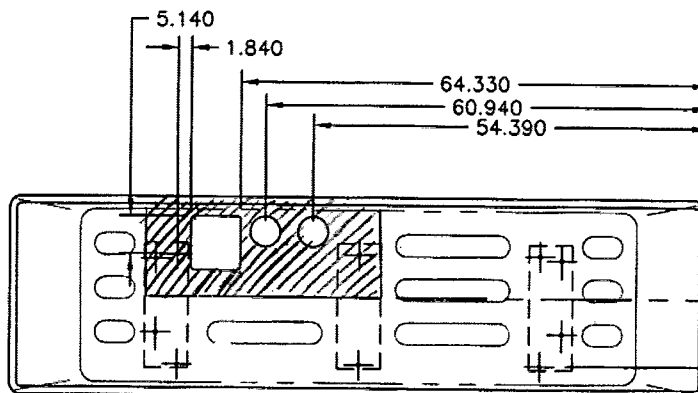
TO AMEND D2202 REV. F

TO MAKE A D2202-5 BASE (FOR D350-602-013) FROM A D2202-3 BASE :

- 1) REMOVE FOAM IN SHADED AREA OF POD.
- 2) FILL GAPS WITH 90Z SATIN AND RESIN PER DWG (APPROX. 3-4 LAYERS)
- 3) 2 LAYERS OF 90Z SATIN
- 4) INSTALL D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) INSTALL DOUBLER WITH AD64ABS RIVETS (46) AND MS24693S212 SCREWS (3)
- 6) CUT HOLES AND SEAL WITH CYANOACRYLATE GLUE
- 7) TOUCH UP SPACKLE GREY FINISH AND CLEARCOAT

RELEASED

04.10.14



HINGE SIDE

D2202-5 POD BASE

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DESIGN <i>97/13</i>	DRAWN BY <i>DC</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2694	REV. H SHEET 1 OF 4
DATE 07.07.18		TITLE UTILITY POD ASSEMBLY	SCALE NTS
A	97.07.02	NEW ISSUE CREATED TO REPLACE D350-602-041 AND -043	
B	97.10.08	CHANGE RIVET PATTERN, ADD D2429	
C	98.11.12	ADD DOUBLER HOLES, REMOVE FINISH	
D	99.01.08	SEAL & HINGE CHANGE (TSR A1047 & A855/A858); INCLUDED DE09119	
E	99.12.20	CHANGE DIMENSIONS	
F	01.03.20	REDESIGN, CHANGE LATCHES & PROP	
G	01.05.08	REVERT BACK TO D2204-9 LATCH	
H	07.07.18	CHANGED RIVETS FROM AD64ABS TO AD62ABS (PAR#185)	

**RELEASED**  
07.07.23

Qty	Part Number	Description
1	D2202-1	POD LID
1	D2202-3	POD BASE
5	D2204-9	LATCH
1	D2429-041	SPRING CLIP ASSEMBLY
1	D2462-1700	NEOPRENE SEAL
5	D2528-1	BACKER PLATE
4	D2528-3	BACKER PLATE
1	D2569	HINGE
1	D3007-041	PROP ASSEMBLY
19	AN4-5A	BOLT
1	AN4-6A	BOLT
2	AN526C632R7	SCREW
21	AN960JD416	WASHER
2	AN960JD6	WASHER
2	MS21042L06	NUT (OR MS21042-06)
20	MS21042L4	NUT (OR MS21042-4)
38	AD62ABS	RIVET



**GENERAL NOTES:**

- TRANSFER DRILL UNSPECIFIED HOLES FROM ATTACHING PART AS FOLLOWS: AN526C632 → DRILL Ø0.141  
AN4 → DRILL Ø0.257
- SEAL ALL HOLES AND EDGES OF POD WITH CYANOACRYLATE GLUE
- FOR D2569 HINGE:
  - INSTALL RIVET HEADS FROM OUTSIDE OF POD
  - GRIND TRAILING EDGE OF RIVET TO PERMIT HINGE TO CLOSE
  - ENSURE ALL RIVET HOLES ARE DRILLED ON THE LARGER HINGE TABS AS SHOWN IN DETAIL A
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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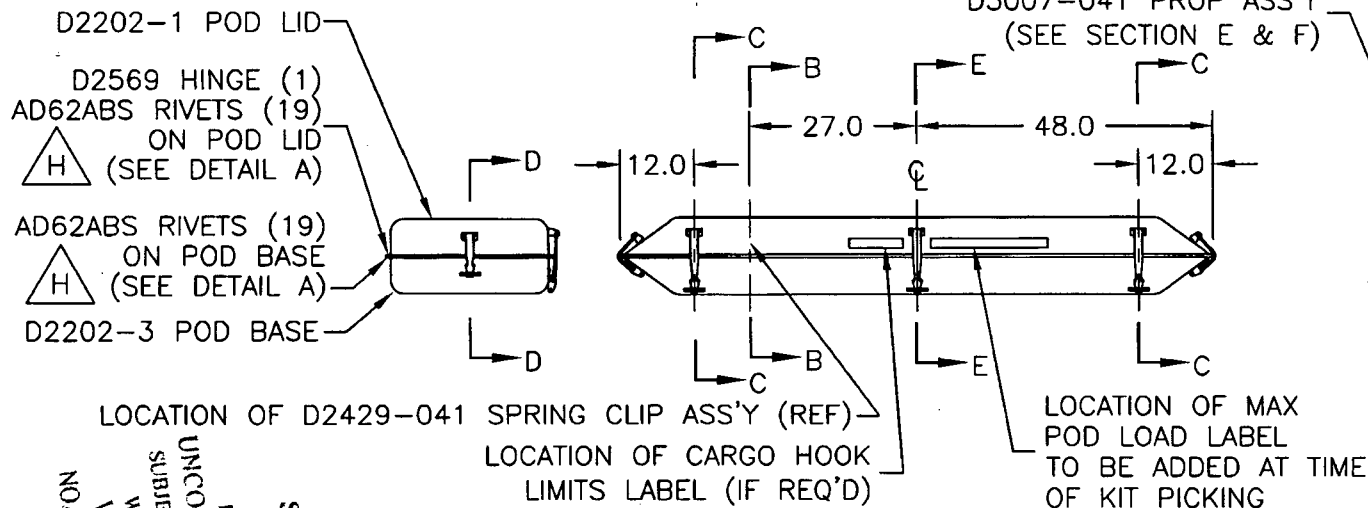
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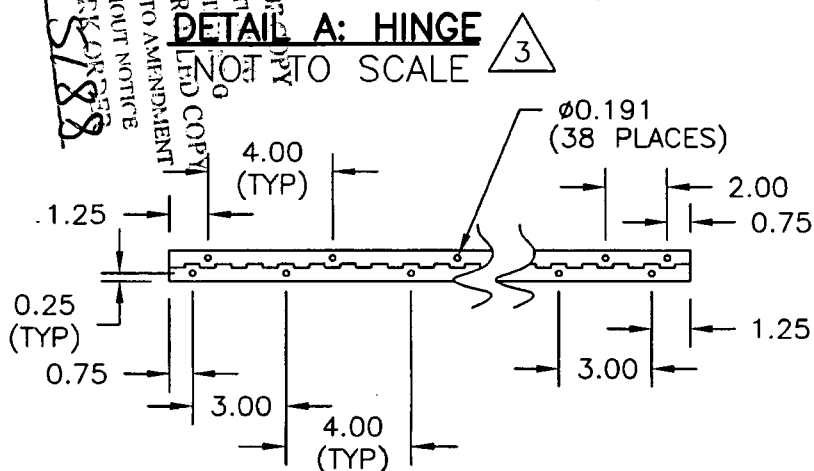
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CHECKED	JS	APPROVED	JS	
DATE	07.07.18	DRAWING NO.	D2694	
TITLE	UTILITY POD ASSEMBLY	REV. H	SHEET 2 OF 4	
SCALE	1:30			

D3007-041 PROP ASS'Y  
(SEE SECTION E & F)

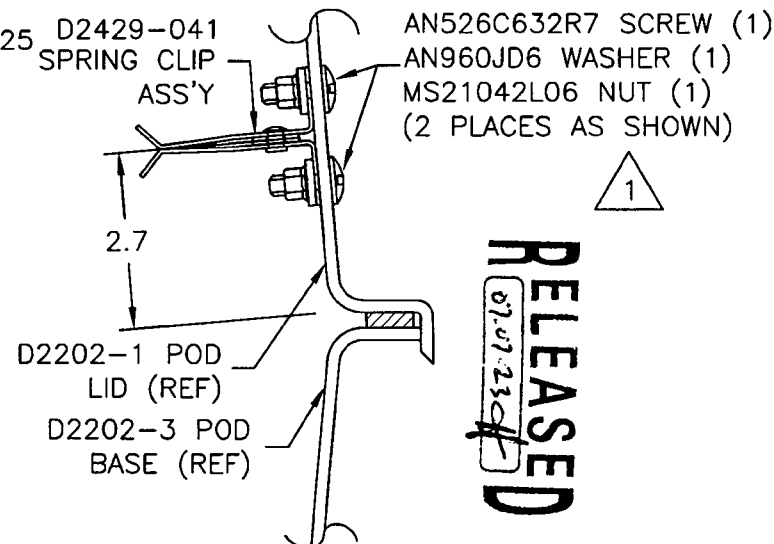


INSTALL D2462-1700 NEOPRENE  
SEAL ALONG TOP INSIDE EDGE OF  
LID (USE CONTACT CEMENT)

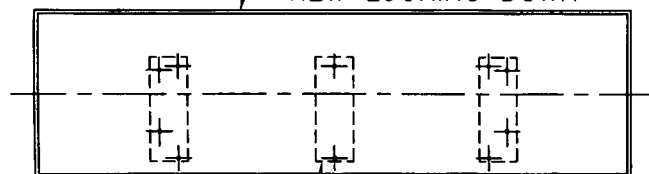
**DETAIL A: HINGE**



**SECTION B-B**  
SCALE 2:3



D2202-3 POD BASE (REF)  
VIEW LOOKING DOWN



NOTE ORIENTATION OF  
DOUBLERS IN POD BASE  
INSTALL HINGE  
ON THIS EDGE

**RELEASED**  
07.07.2018



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DATE 07.07.18		TITLE UTILITY POD ASSEMBLY	SCALE 1:2

**RELEASED**  
07.07.23

D2528-1 BACKER PLATE

D2202-1 POD LID (REF)

AN4-5A BOLT (1)  
AN960JD416 WASHER (1)  
MS21042L4 NUT (1)  
(2 PLACES)

D2204-9 LATCH

**SECTION C-C**  
SCALE 1:2

1 AN4-5A BOLT (1)  
AN960JD416 WASHER (1)  
MS21042L4 NUT (1)  
(2 PLACES AS SHOWN)

D2202-3  
POD BASE (REF)

1 AN4-5A BOLT (1)  
AN960JD416 WASHER (1)  
MS21042L4 NUT (1)  
(2 PLACES)

**SECTION D-D**  
SCALE 1:2

D2528-1  
BACKER PLATE

D2528-3  
BACKER PLATE

D2202-3  
POD BASE  
(REF)

D2202-1  
POD LID  
(REF)

3.00  
(REF)

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D2204-9  
LATCH

0.45  
(REF)

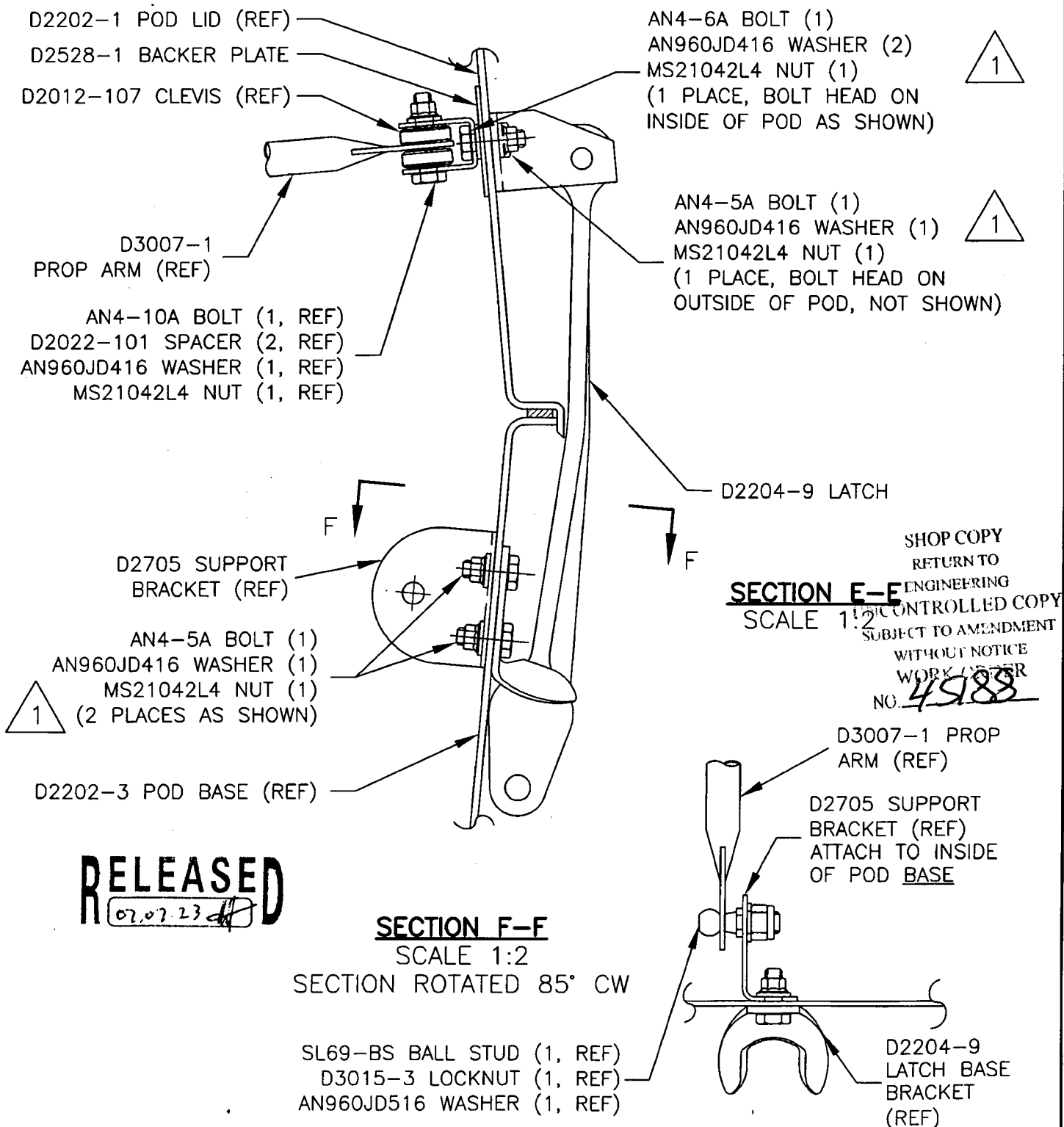
1 AN4-5A BOLT (1)  
AN960JD416 WASHER (1)  
MS21042L4 NUT (1)  
(2 PLACES AS SHOWN)

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DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2694	REV. H SHEET 4 OF 4
DATE 07.07.18		TITLE UTILITY POD ASSEMBLY	SCALE 1:2



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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2202	REV. F SHEET 1 OF 4
DATE 01.03.14		TITLE UTILITY POD LID AND BASE	SCALE NTS
A	93.10.27	NEW ISSUE	
B	96.12.16	ADD DOUBLERS AND HOLES	
C	97.07.04	REVISED DOUBLER/HOLE LOCATIONS	
D	98.11.09	MOVED DOUBLERS, REMOVED HOLES	
E	99.11.11	ADDED SECTIONS WITH LIP DIMS	
F	01.03.14	CHANGE LAYUP, DOUBLER, NOW DRILLED	
F1	<del>CP</del> 03.05.08	ADD ALTERNATE FINISH	
F2	<del>CP</del> 03.08.22	CLARIFY FOAM DIMENSION + PLACEMENT.	
F3	<del>CP</del> 04.10.12	CHANGE FOAM P/N PER NCR 748	

RELEASED  
01.03.30 [Signature]

EFFECTIVE	DEOs
Des 9217 Rev. A 01.07.26 [Signature]	

1) LAMINATE PER DART QSI 006.  
LAMINATION SCHEDULE PER THIS DRAWING.

2) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE  
470-36/411/510A40

FOAM: A500 CORE-CELL, OR DIVINYCELL,  
OR AIREX, 0.38 THICK (3/8 FOAM)

FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS (9oz SATIN)  
5 OZ PLAIN WEAVE KEVLAR (5oz KEVLAR)

3) PEEL PLY ALL SURFACES.

4) FINISH: PRIMER, EPOXY PRIMER WHITE 4500-PB-40  
BASE COAT, CHROMATE BASEMAKER 9175S  
URETHANE CLEAR COAT, CHROMATE 7500S

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5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

6) ALL DIMENSIONS ARE IN INCHES.

7) ALTERNATE FINISH : INSIDE → DUPONT HIGHBUILD GREY PRIMER 1144-S  
OUTSIDE → WHITE GELCOAT # GEL 944WDOS

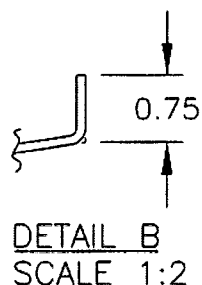
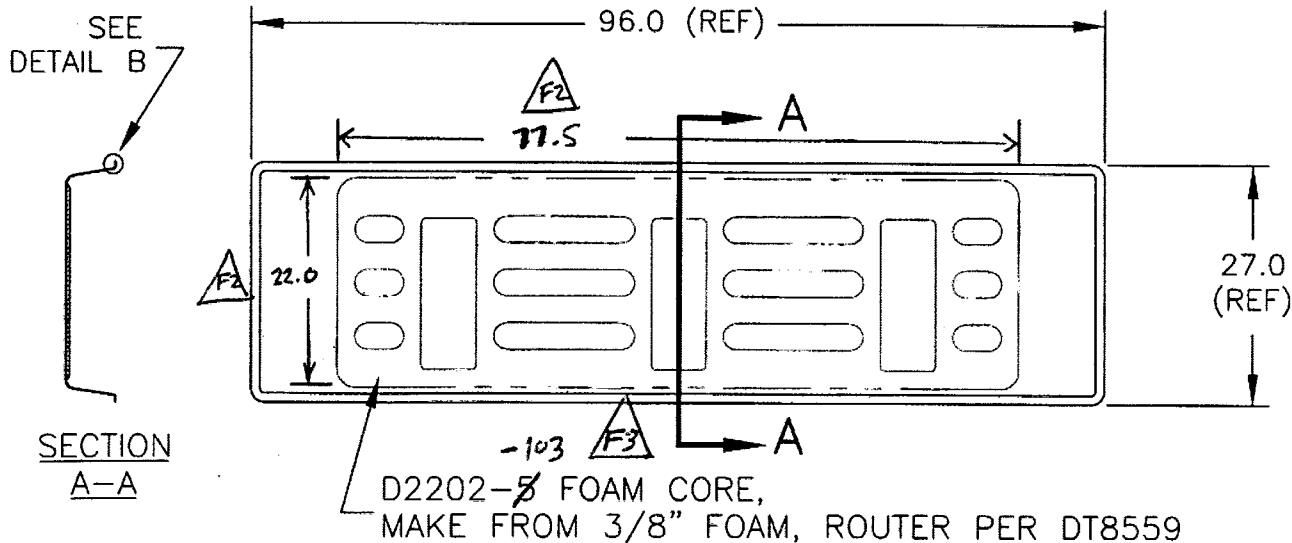


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DATE 01.03.14		TITLE UTILITY POD LID AND BASE	SCALE 1:20



D2202-3 BASE  
(MOLD DT8002)

MAIN LAYUP

9oz SATIN  
9oz SATIN  
5oz KEVLAR  
 $\triangle F3$  D2202-103 ~~D2202-5~~ FOAM CORE  
5oz KEVLAR  
5oz KEVLAR  
9oz SATIN

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RELEASED  
01.03.30 *A*

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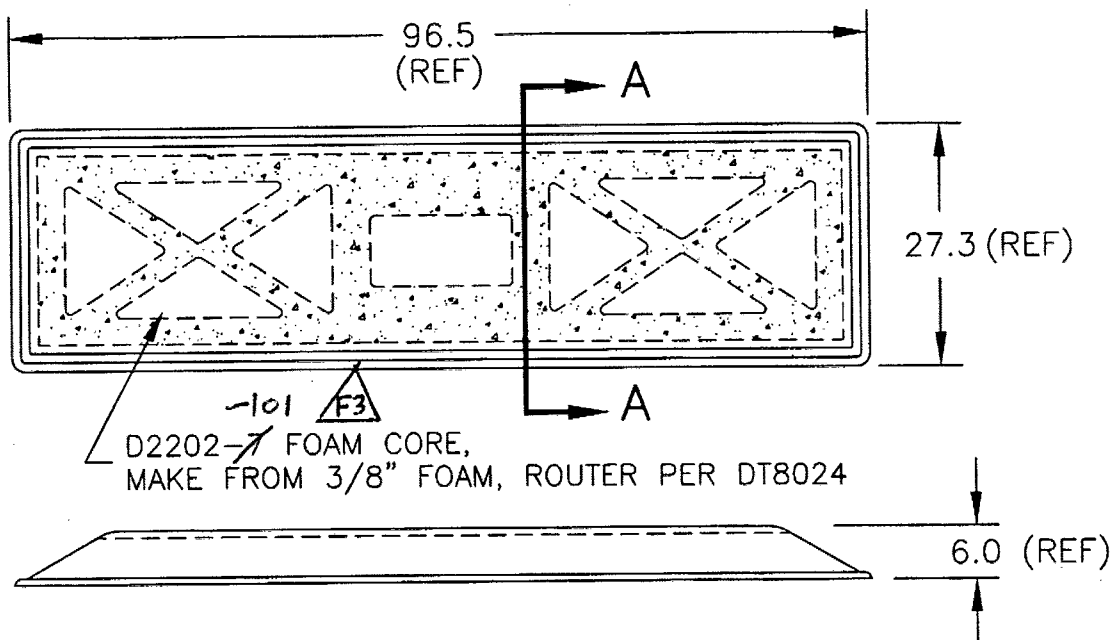




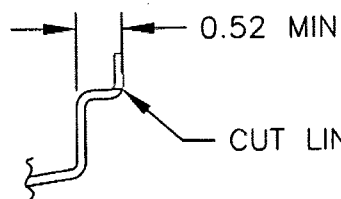
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DATE 01.03.14		TITLE UTILITY POD LID AND BASE	SCALE 1:20

SEE  
DETAIL B

SECTION  
A-A



D2202-1 LID  
(MOLD DT8002)



DETAIL B  
SCALE 1:2

MAIN LAYUP

9oz SATIN  
9oz SATIN  
5oz KEVLAR  
D2202-7 FOAM CORE  
5oz KEVLAR  
9oz SATIN

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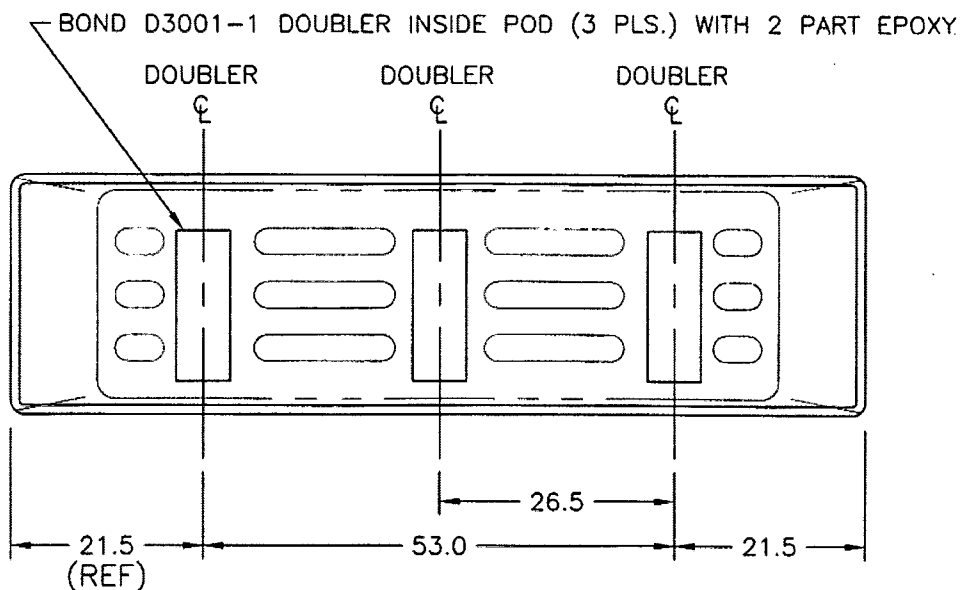
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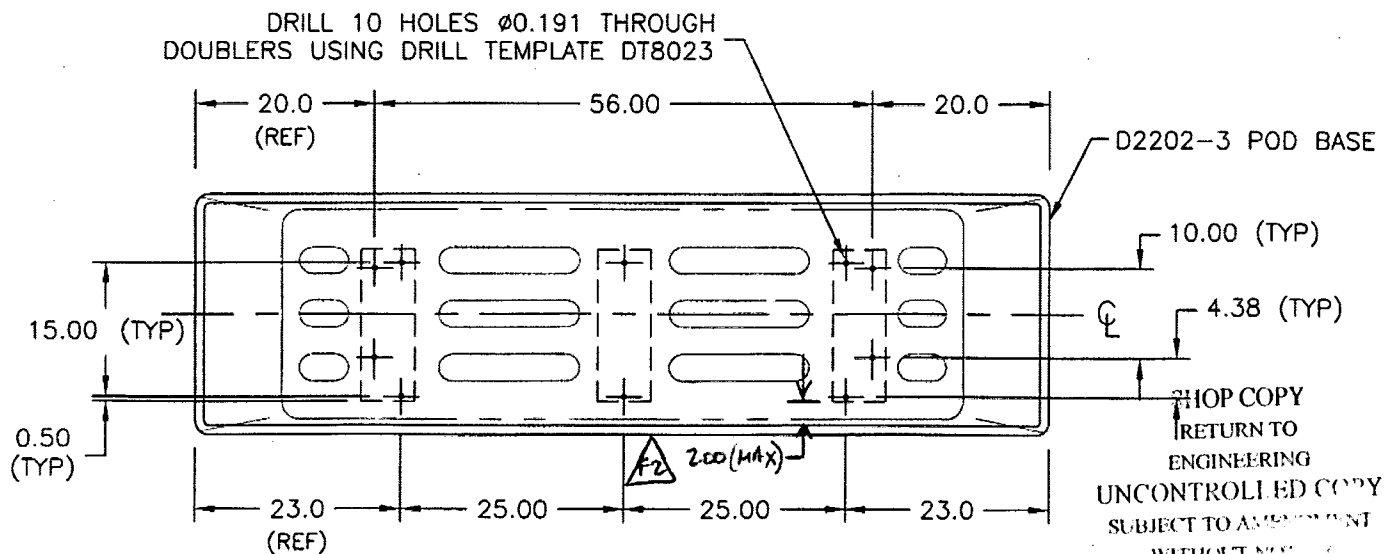


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D2202	REV. F SHEET 4 OF 4
DATE 01.03.14		TITLE UTILITY POD LID AND BASE	SCALE 1:20

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01.03.30



D2202-3 BASE: DOUBLER INSTALLATION



D2202-3 BASE: DRILL DETAIL

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NO 45188

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DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13111
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
18/03/2009	04/02/2009	5972	Chantal Lavoie		PQ00008131		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0014	D2202-1 Side Pod Lid B45188 Référence DKA362-0015 DWG: REV. F Job: 43646			
1	0	1	DKC134-0068	D2202-5 Side Pod Base B45188 DWG: D2202 Rév.: F; DEO 9217 Rév.: A  <div> <div>No. lot</div> <div>43750</div> </div>			

U de M : Eac

Sorlos

Qté

1

Finished items were

U de M : Eac

Scorlosio Qté  
1

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AQ-357

☒ Cust.

☐ Adm.

☐ Quality

☐ Ship.



Date: Lundi, 2009-02-09 09:58:33  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : UTILITY POD LID
Numéro Job : 43646		Numéro Article : DKC134-0014
Numéro Soumission : 1742		Numéro Dessin : D2202
Numéro B.A. :		Projet Numéro : DKC134
Cette fois : 2009-02-09	No. B.V. :	Révision dessin : F
Prsht Rev. : NC		Matériel : Résine Derakane 470-36/411/510
Prem. fois : - -	Type :	Date Dûe : 2009-02-16
Job précédente : 43522		Qté: 1 Udm: UNITE

Écrit par : 

Vérifié & Approuvé par :

Commentaires : N° de pièce Laminée Dart Aerospace: D2202-1  
N° de pièce Delastek Aéronautique: DKA362-0015  
N° de pièce Delastek Composites: DKC134-0014

Process Sheet Rév.: 10 Modification du planning afin d'y inclure le  
N° I.G 0008 ( Primer )

Produit additionnel )

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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1.0	AC0303	Freekote 44NC
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Commentair Qty.: 0.030 GALLON(s)/Unit Total : 0.030 GALLON(s)  
Freekote 44NC

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
PRÉPARATION DU MOULE

Faire la préparation du moule N° DT8002 en appliquant une couche de Freekote 44NC et ensuite laisser sécher pendant 3 heures avant de passer à l'étape suivante.

16-02-09



3.0	AAC0273	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Commentair Qty.: 1.250 GALLON(s)/Unit Total : 1.250 GALLON(s)  
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-6984-1

4.0	AAC0275	Catalyst N° DDM-9
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Commentair Qty.: 0.0095 PINTE(s)/Unit Total : 0.0095 PINTE(s)  
Catalyst N° DDM-9 N° de Lot: 1-6118-3

5.0	AC0260	Acetone
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Commentair Qty.: 0.375 KILOGRAMME(s)/Unit Total : 0.375 KILOGRAMME(s)  
Acetone

6.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation du matériel :

Date: Lundi, 2009-02-09 09:58:33  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43646

Nom Dessin: UTILITY POD LID  
Numéro Article: DKC134-0014

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Dans une quantité de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

16-02-09



7.0

GEL COAT.

APPLICATION DE GEL COAT



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
APPLICATION DE GEL COAT

À l'aide d'un fusil à peinture appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DT8002 et laisser sécher pendant un minimum de 12 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

16-02-09



Autocontrôle de fabrication. ( Visuel du Gel Coat )

8.0

AAC0326

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentaire Qty.: 9.9 VERGE(s)/Unit Total : 9.9 VERGE(s)

9.7 oz 7781 Weave "S" glass #FG-778150-125Y

N° de Lot:

1-6925-1

9.0

AC0409

Tissu à délaminer Release ply B

Commentaire Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s)

Tissu à délaminer Release ply B

10.0

AAC0319

5oz plain weave Kevlar 50" wide roll

Commentaire Qty.: 6.6 VERGE(s)/Unit Total : 6.6 VERGE(s)

5oz plain weave Kevlar 50" wide roll

N° de Lot:

1-6904-1

11.0

AC0407

Wrightlon 5200 Bleu P3

Commentaire Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s)

Wrightlon 5200 Bleu P3

12.0

AC0408

Feutre de drainage N° Airweave N 10

Commentaire Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)

Feutre de drainage N° Airweave N 10

13.0

AC0752

Stretchlon 200 poche à vide Vert

Commentaire Qty.: 42.63 PIED(s)/Unit Total : 42.63 PIED(s)

Stretchlon 200 poche à vide Vert

14.0

AC0098

Ruban à gommer jaune #: T/AT-200Y

Commentaire Qty.: 3.0000 RL(s)/Unit Total : 3.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y

Date: Lundi, 2009-02-09 09:58:34  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43646

Nom Dessin: UTILITY POD LID  
Numéro Article: DKC134-0014

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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15.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
TAILLAGE DU MATÉRIEL

Faire le tailage du matériel selon les Dimensions requises:

Un morceau pour recouvrir le fond du moule N° DT8002.

Deux morceaux pour couvrir les extrémités du moule N° DT8002.

Deux morceaux pour recouvrir les cotés du moule N° DT8002.

Faire cette opération pour les trois plis de 9 oz ainsi que pour les deux plis de 5 oz de Kevlar.

Tailler le matériel nécessaire pour la poche à vide ( Faire 3 kits car il y aura trois baggings différents lors de la fabrication de cette pièce):

Peel Ply

Film Durisol P-3

Feutre de drainage 6m

Stretchlon 200

16-02-09



Coller une bande de ruban jaune tout le tour du Stretchlon 200, plier les différentes composantes des poches à vide et entreposer en attente des opérations de bagging.

16.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
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Commentaire Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-23335-1

17.0	AAC0275	Catalyst N° DDM-9
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Commentaire Qty.: 0.0845 PINTE(s)/Unit Total : 0.0845 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-6118-3

18.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

Mélanger la quantité de résine désirée pour le laminage des trois premier plis du Pod Lid : 2% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 Min.

16-02-09



Date: Lundi, 2009-02-09 09:58:34  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43646

Nom Dessin: UTILITY POD LID  
Numéro Article: DKC134-0014

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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19.0	LAMINAGE.	LAMINAGE PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
FAIRE LE LAMINAGE DES TISSUS

Faire le laminage des trois premiers plis de tissu ( 2 plis de 9 oz et 1 pli de 5 oz Kevlar ) de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 Minutes, ensuite venir laminer un pli de 9 oz dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. ( Ajouter de la résine au besoin )

16-02-09



Recommencer pour les deux autres plis. ( un pli de 9 oz et un pli de 5 oz Kevlar )

20.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide sur le moule N° DT8002, assurez vous qu'il n'y aie aucunes pertes de vacuum.

Laisser sécher jusqu'au lendemain.

16-02-09



21.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
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Commentair Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-23335-1

22.0	AAC0275	Catalyst N° DDM-9
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Commentair Qty.: 0.0135 PINTE(s)/Unit Total : 0.0135 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-6118-3

23.0	DKC134-0022	D2202-7 Foam Core ( Utility Pod Lid )
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
D2202-7 Foam Core ( Utility Pod Lid )

43526

24.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

12-02-09



Faire un mélange de résine Derakane 411-350 Promoté 15 à 18 Minutes 2% de catalyst DDM-9 par quantité de résine.

Date: Lundi, 2009-02-09 09:58:34  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43646

Nom Dessin: UTILITY POD LID  
Numéro Article: DKC134-0014

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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25.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
ASSEMBLAGE GÉNÉRALE DES PIECES

À l'aide d'un rouleau, appliquer une couche de résine sur toutes les surfaces du Foam Core N°  
DKC134-0022 et positionner le foam Core dans le moule selon le dessin.

12-02-09



Laisser sécher pendant deux heures.

26.0	AAC0452	Polybond B46F
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Commentair Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s)  
Polybond B46F N° de Lot: 1-6724-1

27.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
ASSEMBLAGE GÉNÉRALE DART

17-02-09



Faire l'assemblage du Foam Core N° DKC134-0022 à l'aide du polybond 64F

28.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide sur le moule N° DT8002, assurez vous qu'il n'y aie aucunes pertes de vacuum.

17-02-09



Laisser sécher 1 heure.

29.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
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Commentair Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-23335-1

30.0	AAC0275	Catalyst N° DDM-9
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Commentair Qty.: 0.0845 PINTE(s)/Unit Total : 0.0845 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-6118-3



Date: Lundi, 2009-02-09 09:58:34  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43646

Nom Dessin: UTILITY POD LID  
Numéro Article: DKC134-0014

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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31.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

18-02-09



Mélanger la quantité de résine désirée pour le laminage des deux derniers plis du Pod Base: 2% de catalyst  
DDM-9 par quantité de résine Derakane 411-350 Promoté 75 minutes.

32.0	LAMINAGE.	LAMINAGE PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
FAIRE LE LAMINAGE DES TISSUS

Faire le laminage des deux dernier plis de tissu ( 1 plis de 5 oz Kevlar et 1 pli de 9 oz) de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 minutes,  
ensuite venir laminer un pli de 5 oz Kevlar dans le fond du moule, suivre avec les deux extrémités et terminer  
avec les deux cotés. ( Ajouter de la résine au besoin )

18-02-09



S.V.

Recommencer pour le dernier plis. ( un pli de 9 oz )

33.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide sur le moule N° DT8002, assurez vous qu'il n'y aie aucunes pertes de vacuum.

Laisser sécher jusqu'au lendemain.

18-02-09



S.V.

34.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
DÉMOULAGE DES PIECES

19-02-09



Faire le démoulage du Utility Pod Lid en faisant bien attention de ne pas endommager la piece.

Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide du  
manche d'un tournevis.

Date: Lundi, 2009-02-09 09:58:34  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43646

Nom Dessin: UTILITY POD LID  
Numéro Article: DKC134-0014

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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35.0	AC0058	Polysoft 1.3 kg # 003012 Sikkens
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Commentair Qty.: 0.125 UNITE(s)/Unit Total : 0.125 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6893-1

36.0	AC0059	Durcisseur Polysoft #004009 Sikkens
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Commentair Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens

37.0	FINITION 3	FINITION PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION GÉNÉRALE

Sabler légèrement toute la surface intérieur du pod à l'aide de papier sablé grit 120.

Vérifier la surface intérieur du pod et injecter à l'aide d'une seringue munit d'une aiguille de la résine au endroit où il y a des bulles d'air.

Corriger les imperfection de surface à l'aide du Sikkens Polysoft.

19-02-09



Laisser sécher jusqu'au lendemain.

38.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
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Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
TRIMAGE DE FINITION

Faire le trimage du Pod Lid selon le dessin Page 3 de 4 Détail B

19-02-09



Autocontrôle du trimage du pod.

39.0	AAC0683	Dupont Primer N° 7704S
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Commentair Qty.: 0.4333 UNITE(s)/Unit Total : 0.4333 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-21723-1

40.0	AAC0685	Dupont Activator - Reducer Chromabase N° 7775S
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Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)  
Dupont Activator - Reducer Chromabase N° 7775S

41.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
Préparation du matériel

Bien brasser les contenants servant à faire le mélange du primer gris N° 7704S et ensuite faire le mélange selon les directives suivantes:

Date: Lundi, 2009-02-09 09:58:34  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43646

Nom Dessin: UTILITY POD LID  
Numéro Article: DKC134-0014

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Inscrire la température ambiante.

Température: 70.5 °F

60° - 70°F Chromabase 7765S Acticator-Reducer N° de Lot: \_\_\_\_\_

70° - 80°F Chromabase 7775S Acticator-Reducer N° de Lot: 1-21746-2

80° - 90°F Chromabase 7785S Acticator-Reducer N° de Lot: \_\_\_\_\_

90° - 100°F Chromabase 7795S Acticator-Reducer N° de Lot: \_\_\_\_\_

Date: 23/02/09 Sceau:



42.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
PRÉPARATION DU MATÉRIEL

*Nettoyage sty 1 23-02-09*



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 7704S et ensuite faire le mélange selon les instruction du fabricant.

43.0

PEINT/ PRIMER2

PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
APPLICATION DE PEINTURE

*1x 23/02/09*



Appliquer une généreuse couche de primer Gris N° 1104S sur toutes les surfaces intérieur du pod lid (environ 2/3 de la quantité total)

Laisser sécher pendant 3 heures.

Autocontrôle de fabrication.( visuel du primer )

44.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

*24-02-09*



Faire le sablage au grit 180 de la surface primé pour enlever les imperfections restantes.

Date: Lundi, 2009-02-09 09:58:34  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43646

Nom Dessin: UTILITY POD LID  
Numéro Article: DKC134-0014

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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45.0	AAC0683	Dupont Primer N° 7704S
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Commentair Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-21723-1

46.0	AAC0685	Dupont Activator - Reducer Chromabase N° 7775S
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Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)  
Dupont Activator - Reducer Chromabase N° 7775S

47.0	PRIMER	APPLICATION DE PRIMER
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Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

Quantité: 1 Date: 11/03/09 Sceau:

Quantité: 1 Date: 16/03/09 Sceau:

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

48.0	INSPECTION 3	INSPECTION PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
INSPECTION GÉNÉRALE

IX 17-3-09



7.5

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

49.0	EMBALLAGE	EMBALLAGE ET ENTREPOSAGE
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
EMBALLAGE ET ENTREPOSAGE


Faire l'emballage des pièces.

Quantité: 1 Date: 18-3-09 Sceau:

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

Mercredi, 2009-03-18 13:35:38  
Marc Dubé

## Feuille de Procédé

Job : DART Dart Aerospace Ltd.  
Numéro Article : 43750  
Numéro Dessin : 2645A. : 2009-03-18 No. B.V. :  
: NCs :  
édente : Type : Approuvé par  
Initiales

: N° de pièce Laminée Dart Aerospace: D2202-5

Process Sheet Rév.: 00 Création du premier en fonction du  
DKC134-0015Nom Dessin : UTILITY POD BASE  
Numéro Article : DKC134-0068  
Numéro Dessin : D2202  
Projet Numéro : DKC134  
Révision dessin : F (DEO 9217: A)  
Matériel : Résine Derakane 470-36/411/510  
Date Dûe : 2009-03-25

Qté:

1 Udm: UNITE

additionnel

o Job:



Séq.:

Machine ou Opération:

Description :

Frekote 44NC

1.0 AC0303

Commentair Qty.: 0.030 GALLON(s)/Unit Total : 0.030 GALLON(s)

2.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la préparation du moule N° DT8002 Selon IG 0009 &amp; IF134-0011

Date : Sceau:

3.0 AAC0273

Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 0.125 GALLON(s)/Unit Total : 0.125 GALLON(s) 1-6984-1

4.0 AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0095 PINTE(s)/Unit Total : 0.0095 PINTE(s) 1-22176-1

5.0 AC0260

Acetone

Commentair Qty.: 0.375 KILOGRAMME(s)/Unit Total : 0.375 KILOGRAMME(s)

6.0 GEL COAT.

APPLICATION DE GEL COAT



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Appliquer une couche de Gel Coat sur le moule N° DT8002 Selon IG 0019 &amp; IF134-0011

Date: 19-02-09 Sceau:



Date: Mercredi, 2009-03-18 13:35:38

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: UTILITY POD BASE

Numéro Job: 43750

Numéro Article: DKC134-0068

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
7.0	AAC0326	9.7'oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 9.9 VERGE(s)/Unit Total : 9.9 VERGE(s) 1-6925-1

8.0	AAC0319	5oz plain weave Kevlar 50" wide roll
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Commentair Qty.: 9.9 VERGE(s)/Unit Total : 9.9 VERGE(s) 1-6904-1

9.0	AC0409	Tissu à délaminer Release ply B
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Commentair Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s)

10.0	AC0407	Wrightlon 5200 Bleu P3
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Commentair Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s)

11.0	AC0085	Film durisol # 3001792
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Commentair Qty.: 12.500 METRE CAR(s)/Unit Total : 12.500 METRE CAR(s)

12.0	AC0408	Feutre de drainage N° Airweave N 10
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Commentair Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)

13.0	AC0752	Stretchlon 200 poche à vide Vert
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Commentair Qty.: 42.63 PIED(s)/Unit Total : 42.63 PIED(s)

14.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
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Commentair Qty.: 3.0000 RL(s)/Unit Total : 3.0000 RL(s)

15.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le taillage du matériel et le Matériel pour le Bagging selon IF134-0011 & IG 0012

Date: 16-02-09 Sceau:

16.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
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Commentair Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s) 1-23335-1

17.0	AAC0275	Catalyst N° DDM-9
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Commentair Qty.: 0.0845 PINTÉ(s)/Unit Total : 0.0845 PINTÉ(s) 1-22176-1

18.0	LAMINAGE.	LAMINAGE PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire le laminage des tissus selon IF134-0011

Date: 20-2-09 Sceau:

19.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vise selon IG 0012

Date: Mercredi, 2009-03-18 13:35:38  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43750

Nom Dessin: UTILITY POD BASE  
Numéro Article: DKC134-0068

Numéro Job:



# Séq.: Machine ou Opération: Description :

Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

20.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.400 KILOGRAMME(s)/Unit Total: 0.400 KILOGRAMME(s)

1-23335-1

21.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0135 PINTE(s)/Unit Total: 0.0135 PINTE(s)

1-6118-3

22.0 DKC134-0021 D2202-103 Foam Core ( Utility pod Base )

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

43652

23.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Sceller le Foam Core N° DKC134-0021 selon IG 0105

Date: 20-2-09 Sceau:  

24.0 AAC0452 Polybond B46F

Commentair Qty.: 0.150 KIT(s)/Unit Total: 0.150 KIT(s)



1-6724-1

25.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'assemblage du Foam Core N° DKC134-0021 Selon IG 0033.



Date: 23-2-09 Sceau:  

26.0 POCHE A VIDE EFFECTUER LA POCHE A VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012

Date: 23-2-09 Sceau:  

27.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.500 KILOGRAMME(s)/Unit Total: 2.500 KILOGRAMME(s)

1-23335-1

28.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0845 PINTE(s)/Unit Total: 0.0845 PINTE(s)

1-6118-3

29.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire le laminage des trois dernier plis selon IF134-0011.

Date: Mercredi, 2009-03-18 13:35:38  
Utilisateur: Marc Dubé

## Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.  
Numéro Job: 43750

Nom Dessin: UTILITY POD BASE  
Numéro Article: DKC134-0068

Numéro Job:



# Séq.: Machine ou Opération: Description :

Date: 20-2-09 Sceau: C.B. N.T.

30.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Date: 25-2-09 Sceau: 34 7 S.V. M.A.

31.0 AAC0649 D3001-1 Doubler ( Pod Base D2002-3)

Commentaire Qty.: 3 UNITE(s)/Unit Total: 3 UNITE(s)

1-6995-1

32.0 AC0355 Araldite 2043

Commentaire Qty.: 0.5 UNITE(s)/Unit Total: 0.5 UNITE(s)

LOT: N/A

33.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Coller les trois doublers N° D3001-1 Selon IF134-0011

Faire trois petites poches à vide selon IG 0012.

Date: 26-2-09 Sceau: 34 7

34.0 AC0355 Araldite 2043

Commentaire Qty.: 0.5 UNITE(s)/Unit Total: 0.5 UNITE(s)

Araldite 2043

N° de Lot: N/A

35.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

FINITION GÉNÉRALE

Retirer les trois poches à vide et faire un joint tout autour des trois doublers à l'aide d'Araldite 2043 et laisser sécher jusqu'au lendemain.

36.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

DÉMOULAGE DES PIÈCES








Faire le démoulage du Utility Pod Base en faisant bien attention de ne pas endommager la pièce.

Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide du



Date: Mercredi, 2009-03-18 13:35:38  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: UTILITY POD BASE	
Numéro Job: 43750		Numéro Article: DKC134-0068	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
	manche d'un tournevis.		
37.0	AC0058	Polysoft 1.3 kg # 003012 Sikkens	
Commentaire Qty.: 0.125 UNITE(s)/Unit Total : 0.125 UNITE(s) Polysoft 1.3 kg # 003012 Sikkens N° de Lot: <u>1-6893-1</u>			
38.0	AC0059	Durcisseur Polysoft #004009 Sikkens	
Commentaire Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s) Durcisseur Polysoft #004009 Sikkens			
39.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs FINITION GÉNÉRALE  Sabler légèrement toute la surface intérieur du pod à l'aide de papier sablé grit 120.  Vérifier la surface intérieur du pod et injecter à l'aide d'une seringue munit d'une aiguille de la résine au endroit où il y a des bulles d'air  Corriger les imperfections de surface à l'aide du sikkens Polysoft.  Laisser sécher jusqu'au lendemain			
40.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs TRIMAGE DE FINITION  Faire le trimage du Pod Base selon le dessin Page 2 de 4 Détail B  Autocontrôle du trimage du pod.			
41.0	AAC0683	Dupont Primer N° 7704S	
Commentaire Qty.: 0.4333 UNITE(s)/Unit Total : 0.4333 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-21723-1</u>			
42.0	AAC0685	Dupont Activator - Reducer Chromabase N° 7775S	
Commentaire Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) Dupont Activator - Reducer Chromabase N° 7775S			
43.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs Préparation du matériel  Bien brasser les contenants servant à faire le mélange du primer gris N° 7704S et ensuite faire le mélange			

Date: Mercredi, 2009-03-18 13:35:38  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43750

Nom Dessin: UTILITY POD BASE  
Numéro Article: DKC134-0068

Numéro Job:



# Séq.: Machine ou Opération: Description :

selon les directives suivantes:

Inscrire la température ambiante.

Température: 70.3 °F

60° - 70°F Chromabase 7765S Acticator-Reducer N° de Lot: \_\_\_\_\_

70° - 80°F Chromabase 7775S Acticator-Reducer N° de Lot: 1-21746-2

80° - 90°F Chromabase 7785S Acticator-Reducer N° de Lot: \_\_\_\_\_

90° - 100°F Chromabase 7795S Acticator-Reducer N° de Lot: \_\_\_\_\_

Date: 10-3-09 Sceau:

44.0

PEINT/ PRIMER2

PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
APPLICATION DE PEINTURE

Appliquer une couche généreuse de primer Gris N° 7704S sur toutes les surfaces intérieur du pod base (environ 2/3 de la quantité)

Laisser sécher pendant 3 heures.

Autocontrôle de fabrication.( visuel du primer )

45.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

Faire le sablage au grit 180 de la surface primé pour enlever les imperfections restantes.

46.0

AAC0683

Dupont Primer N° 7704S

Commentair Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-21723-1

47.0

AAC0685

Dupont Activator - Reducer Chromabase N° 7775S

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)  
Dupont Activator - Reducer Chromabase N° 7775S

Date: Mercredi, 2009-03-18 13:35:38

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43750

Nom Dessin: UTILITY POD BASE  
Numéro Article: DKC134-0068

Numéro Job:



# Séq.: Machine ou Opération: Description :

48.0

PRIMER

APPLICATION DE PRIMER



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

Quantité: 1 Date: 11-3-09 Sceau: 

Quantité: 1 Date: 11-3-09 Sceau: 

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

49.0


IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
INSPECTION GÉNÉRALE

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Quantité: 1 Date: 17-3-09 Sceau: 

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

50.0


EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1 Date: 18/3/09 Sceau: 

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_